

**Work Order ID 68633**

Tuesday, April 19, 2011 11:53:55 AM



Eagle

Page 1

Item ID: D412-742-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *MC*Date: *11-04-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D412-742	D

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-011 CHG006

*5/16/12**for BG 11-5-10*

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*4/19/10*

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*5/16/12**(#)**B62963*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68633**

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Item ID: D412-742-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD412-742-011 Location: _____								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/5/12

11/5/11

MF  
11-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM  
 IPP Rev: B 06-06-08 As per DSI9336 JLM  
 IPP Rev: C 07-05-28 As per Rev C JLM  
 IPP rev D 07.11.01 ecn 1053P EC  
 IPP rev E 07.11.27 ecn 1072 EC verified by: DD  
 IPP Rev: F 08-09-08 ecn 08-510 DD verified by: EC  
 IPP Rev: G 09-01-23 as per DSI9441 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C37A BOLT		Purchased	No			110	Each	129.0000	3	3			

Location Loc Qty Loc Code

ST353 29

116874 11

117010 18

ST354 100

117343 100

AN3C40A BOLT		Purchased	No			110	Each	103.0000	2	2			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST354 103

106176 3

112454 50

114442 50

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011



Parent Item Name: Float Skidtube Installation


Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00



Required Qty: 1.00


AN3C41A Purchased No 110 Each 152.0000 3 3  

 BOLT

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	148	
116381	8	
117163	60	
117407	80	



116381


AN3C42A Purchased No 110 Each 52.0000 3 3  

 BOLT

Location	Loc Qty	Loc Code
ST354	52	
106176	52	


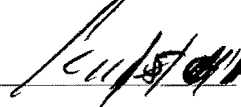
106176


AN3C43A Purchased No 110 Each 88.0000 3 3  

 BOLT

Location	Loc Qty	Loc Code
ST354	88	
114433	28	
114455	20	
117313	40	

1114433

AN3C44A Purchased No 110 Each 99.0000 9 9  

 BOLT

Location	Loc Qty	Loc Code
ST355	99	
110848	99	

110848

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C47A

Purchased

No

110

Each

78.0000

10

10



BOLT

Location

Loc Qty

Loc Code

ST355

78

110847

28

116874

50

110847

AN4C47A

Purchased

No

110

Each

91.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST361

91

115518

6

116003

20

116400

25

117163

40

116003

AN4C52A

Purchased

No

110

Each

104.0000

8

8



BOLT

Location

Loc Qty

Loc Code

ST361

104

113121

4

114784

40

117163

60

114784

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A  
Bolt

Purchased

No

110

Each

344.0000

16

16

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

290

115016

14

116003

126

116400

50

116704

100

116003

AN4C7A  
Bolt

Purchased

No

110

Each

427.0000

4

4

Location

Loc Qty

Loc Code

ST356

427

109147

427

109147  
8

AN6C12A  
BOLT

Purchased

No

110

Each

74.0000

8

Location

Loc Qty

Loc Code

ST342

74

114442

24

116022

30

117366

20

116022

AN960C10L NAS1149C0332 R

Purchased

No

110

Each

0.0000

66

66

washer

1117291 10/11/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C416L

*WASHER 11/16/00*

Purchased

No

110

Each

8.0000

32

32



WASHER



*11/16/00*

*Ca*

Location

Loc Qty

Loc Code

ST350

8

112828

8

110

Each

100.0000

8

8

AN960C616L

Purchased

No



WASHER



*Ca*

Location

Loc Qty

Loc Code

ST347

100

113064

100

110

Each

8.0000

1

1

D2571

Manufactured

No



Saddle, Fwd Out 205



*113064*

*62664*

*Ca*

Location

Loc Qty

Loc Code

ST433

8

63499

8

110

Each

5.0000

1

1

D2572

Manufactured

No



Saddle, Fwd In 205



*63499*

*67663*

*Ca*

Location

Loc Qty

Loc Code

ST433

5

63500

5

110

Each

4.0000

1

1

D2573

Manufactured

No



Saddle, Aft Out 205



*Ca 11/6/10*

Location

Loc Qty

Loc Code

ST434

4

63501

4

*63501*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D2574  
Saddle, Aft In 205

Manufactured No

110 Each

4.0000

1 1

Location

Loc Qty

Loc Code

ST434

4

63502

4

110 Each

110.0000

4

63502

D2747  
Set Screw

Manufactured No

Location

Loc Qty

Loc Code

ST021

110

62085

10

64276

100

110 Each

92.0000

2

64276

D2876  
Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST025

92

66849

44

ST026

48

68282

48

110 Each

111.0000

2

66849

D2877  
Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST025

111

63325

11

66843

40

68283

60

66843

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3403-1 Manufactured No 110 Each 40.0000



Bushing

16 16  
66990

Location Loc Qty Loc Code

ST052 40  
63316 40

D3403-3 Manufactured No 110 Each 50.0000



Bushing

8 8  
66846

Location Loc Qty Loc Code

ST052 50  
59598 9  
62240 1  
66846 40

D3405-041 Manufactured No 110 Each 11.0000



Lug Assembly

1 1  
66846

Location Loc Qty Loc Code

ST474 11  
62227 2  
62958 9

D3405-043 Manufactured No 110 Each 3.0000



Lug Assembly

1 1  
67970

Location Loc Qty Loc Code

ST423 2  
65703 2  
ST474 1  
62959 1

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-041



Tow Ring

Manufactured No

110 Each

4.0000

1

1



68749

*[Signature]*

Location

Loc Qty

Loc Code

ST464

4

62960

4

D3417-3



Washer

Manufactured No

110 Each

112.0000

2

2



*[Signature]*

Location

Loc Qty

Loc Code

FG

9

33519

9

ST053

103

44349

22

51648

28

53182

23

66847

30

44349

D3456-1



Washer

Manufactured No

110 Each

23.0000

1

1



68748

*[Signature]*

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

16

66848

16

66848

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 68633

Parent Item: D412-742-011

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D3533-1

Manufactured No

110 Each

126.0000

2

2



Set Screw

Location

Loc Qty

Loc Code

ST066

126

66138

26

67583

100

66138

D3672-11

Manufactured No

110 Each

635.0000

16

16



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

635

58046

635

58046

32

D3672-3

Manufactured No

110 Each

967.0000

32



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

967

64176

967

64176

8

D3672-9

Manufactured No

110 Each

440.0000

8



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

440

35523

440

35523

1

D412-742-015

CH1601

Manufactured No

110 Each

2.0000

1

1



Electric Step

Location

Loc Qty

Loc Code

FG031A

2

65165

2

65165

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 68633



Parent Item: D412-742-011



Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

D412-742-041 Manufactured No

110

Each

0.0000

1



Replacement Float Skidtube

MS21043-3 Purchased No

100

Each

948.0000

33

33



Nut

B62963

u

## Location

## Loc Qty

## Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

873

112314

873

112314

MS21043-4 Purchased No

110

Each

1,180.000

29

29



Nut

11/6/10

## Location

## Loc Qty

## Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

540

114523

3

116188

237

116549

300

116549

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 5.0 PARTS LIST

## 5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT
		1		D3391-041	412 FLOAT SKIDTUBE
1		*24		*AN3C4A	*BOLT
3		*12		*AN3C6A	*BOLT
4		*8		*AN3C7A	*BOLT
5		*44		*AN960C10L	*WASHER
6		*4		*MS27039C4-12	*SCREW
7A		*4		*D3672-3	*WASHER (REPLACES NAS1515H4L)
7B		*4		*AN960C416L	*WASHER
21A		*1		*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1		*D3566-1	*GASKET
22A		*1		*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1		*D3566-1	*GASKET
23A		*1		*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1		*D3566-5	*GASKET
10		*1		*D3391-011	*412 FORWARD TUBE
11		**1		**D3401-041	**TOW CAP
12A		**10		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2		**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10		**AN3C4A	**BOLT
14A		**4		**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10		**AN960C10L	**WASHER
24A		**1		**D3564-13	**WEARSHOE
24B		**1		**D3566-13	**GASKET
20		*1		*D3391-013	*412 MID TUBE
28		**24		**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1		*D3391-015	*412 AFT TUBE
25A		**1		**D3537-1	**WEARPAD
25B		**1		**D3553-1	**GASKET
26A		**1		**D3537-7	**WEARPAD
26B		**1		**D3553-3	**GASKET
31		**1		**D2646	**AFT CAP
32		**14		**AELS-1032-130	**INSERT
36		**12		**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6		**AN3C4A	**BOLT
37B		**4		**AN3C5A	**BOLT
38A		**2		**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10		**AN960C10L	**WASHER
39		**4		**ALS4-428-165	**INSERT (REPLACES NAS1330S4KB151)

(CONTINUED ON PAGE 17)



(CONTINUED FROM PAGE 16)

Item	Qty -011	Qty -041	Qty -015	Part Number	Description
40	1			D2571	SADDLE, FWD OUTSIDE
41	1			D2572	SADDLE, FWD INSIDE
42	1			D2573	SADDLE, AFT OUTSIDE
43	1			D2574	SADDLE, AFT INSIDE
44	2			D2876	SADDLE SPACER
45	2			D2877	SADDLE SPACER
46	16			D3403-1	BUSHING
47A	4			D2747	SET SCREW
47B	2			D3533-1	SET SCREW
48	16			AN4C6A	BOLT
49	8			AN4C52A	BOLT
50	8			AN6C12A	BOLT
51A	32			D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32			AN960C416L	WASHER
52A	8			D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8			AN960C616L	WASHER
53	16			D3672-11	WASHER (REPLACES NAS1515H7L)
54	24			MS21043-4	NUT
55	4			AN4C7A	BOLT
60	8			D3403-3	BUSHING
61	1			D3405-041	GHW LUG
62	1			D3405-043	GHW LUG
63	4			AN4C46A	BOLT
64	4			MS21043-4	NUT
70	1			D3407-041	TOW RING
71	2			D3417-3	WASHER
72	1			MS21043-4	NUT
73	1			D3456-1	WASHER
80			1	D2913	DOUBLER
81		***4		***ALS4-428-165	***INSERT (REPLACES NAS1329S4KB140)
82		***4		***AELS-1032-130	***INSERT (REPLACES NAS1330S3KB116)
83			2	MS21043-4	NUT
84			2	MS24693-C272	SCREW
85			1	MS35489-35	GROMMET
86			1	MS35489-93	GROMMET
87		***4		***MS27039C1-09	***SCREW
88		***4		***MS27039C4-08	***SCREW
89A		***4	2	***D3672-1	***WASHER (REPLACES NAS1515H3L)
89B		***4	2	***AN960C10L	***WASHER
90A		***4		***D3672-3	***WASHER (REPLACES NAS1515H4L)
90B		***4		***AN960C416L	***WASHER
91	3			AN3C37A	BOLT
92	2			AN3C40A	BOLT
93	3			AN3C41A	BOLT
94	3			AN3C42A	BOLT
95	3			AN3C43A	BOLT
96	9			AN3C44A	BOLT
98	10			AN3C47A	BOLT
99	66			AN960C10L	WASHER
100	33			MS21043-3	NUT

\*DENOTES PART IS INCLUDED WITH D3391-041 ASSEMBLY ABOVE

\*\*DENOTES THAT PART IS INCLUDED ABOVE ASSEMBLY

\*\*\*DENOTES THAT PART IS INCLUDED WITH D3391-013

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Revision: D

Date: 07.10.04



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE  
REF. CANADIAN STC: SH05-37  
REF. EASA STC: EASA.IM.R.S.01126

**REFERENCE ONLY**

## INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

### 5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

### 32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

**IS:**

63	4			AN4C47A	BOLT
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**WAS:**

63	4			AN4C46A	BOLT
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### 5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

### 32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

**IS:**

63	4		AN4C47A	BOLT
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**WAS:**

63	4		AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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